



Dart Hawkesbury
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D4634-141

Job Sheet 167074-D



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	2017-12-13 JSL
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	12/12/15
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	12/12/15
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	DEC 21 1 PD
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 138649 Expiry Date 10/01/25 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-1 <u>5021514</u>	1	3	0	0
	D4636-5 <u>5021513</u>	1	43	0	0
	D4647-5 <u>5021511</u>	1	2	0	0
	D4664-5 <u>5021509</u>	6	39	0	0
	D4712-1 <u>5021506</u>	1	4	0	0
	D4732-15 <u>5021504</u>	1	2	0	0
	D4732-19 <u>5021503</u>	1	1	0	0
	D5021-1 <u>5021501</u>	1	2	0	0
	MPNY-750S-9-C5021499	7	570	0	0
	MS20426AD3-4 <u>5021498</u>	4	5,055	0	0
	MS20426AD4-6 <u>5021496</u>	2	2,797	0	0
	MS21059L08 <u>5021494</u>	2	62	0	0

Part Specifications

Specifications could not be found.

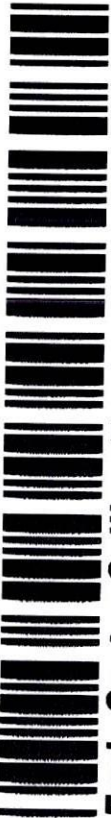
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Cross tube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																
		QTY Effective : _____	MRB (QSI042) Approval															
		Disposition	Completed By															
			Lead hand / Supervisor Approval Verification															
			QC / QA Coordinator Approval															
FAULT CATEGORY																		
Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															

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**Fwd, Center Ceiling Replacement Panel Assembly****D4634 - 141****PART NO:****Revision:****Start up Operation****Operation:****Change No:**
 Mfg Date: 12/13/17
 Job No: 167074-D

 Environment _____
 Design _____
 Doc/Data _____
 Equip/Tooling _____
 Handling/Pre _____
 Material _____
 Internal Transport _____
 Tribal Knowledge _____
 LOA _____
 Substation _____

DART
AEROSPACE
S021556

 Past Expiry Date ☐ Manufacturing Process ☐
 Misidentified ☐ Past Due ☐

OTHER : _____